

Thursday, 23/10/2008 10:53:41 AM
Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER TIE DOWN ASS'Y
Job Number	: 42882		
Estimate Number	: 10360		
P.O. Number	:	Part Number	: D2350
This Issue	: 23/10/2008	Drawing Number	: D2350 / D2363
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B / F
Previous Run	: 41337	Material	:
Written By		Due Date	: 15/11/2008
Checked & Approved By	JDO 08.9.23	Qty:	100
Comment	: est rev B 06.05.17 added ass'y EC Est Rev:C 08-05-13 chg to revF DD verified by:EC	Um:	Each
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	D6201	"T" Extrusion	
Comment: Qty.: 1.0631 f(s)/Unit Total : 6.3788 f(s) 5.3155 Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion 36793		Batch: H.A 08/10/25	
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW Cut blanks: 12.150" long		H.A 08/10/25	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio D2363 and Dwg D2363		H.A 08/10/26	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		H.A 08/10/26	
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK		08/10/27 (B)	
6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Tumble & deburr		H.A. Just 08.10.27	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:53:41 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASSY

Job Number: 42882

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A 08/10/27

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(5X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-F 08/10/07

9.0 POWDER COATING

POWDER COATING



m109/52

(5)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 7:45

OVEN TEMPERATURE: 320°

FINISH TIME: 8:15

F 08/10/28

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-28

(X5)

11.0 D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener 4142C

12.0 D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin 41429

C

13.0 AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer 100753

C

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User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASSY

Job Number: 42882

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) 109031

R

15.0 MS27039113 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw M105211

Re 8/10/28 (5)

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

Eph08/10/29 (5)

17.0 QC5 INSPECT WORK TO CURRENT STEP



Eph08/10/29 (45)

Comment: INSPECT WORK TO CURRENT STEP

18.0 PACKAGING 1 PACKAGING RESOURCE #1



(5X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 105

105

19.0 QC21 FINAL INSPECTION/W/O RELEASE



30

08/10/30 off

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/10/29

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DART AEROSPACE LTD	Work Order:	42882
Description: Litter Tie Down Bracket	Part Number:	D2363
Inspection Dwg: D2363 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>J.A</u>	Audited by:	<u>JNL</u>	Prototype Approval:	N/A
Date:	08/10/26	Date:	08/10/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.22	New Issue P/O D2350	KJ/JLM	
B	07.07.17	Dimensions updated per Dwg Rev. F	KJ/JLM	
C	08.05.20	3.425 dimension removed	KJ/DD	 

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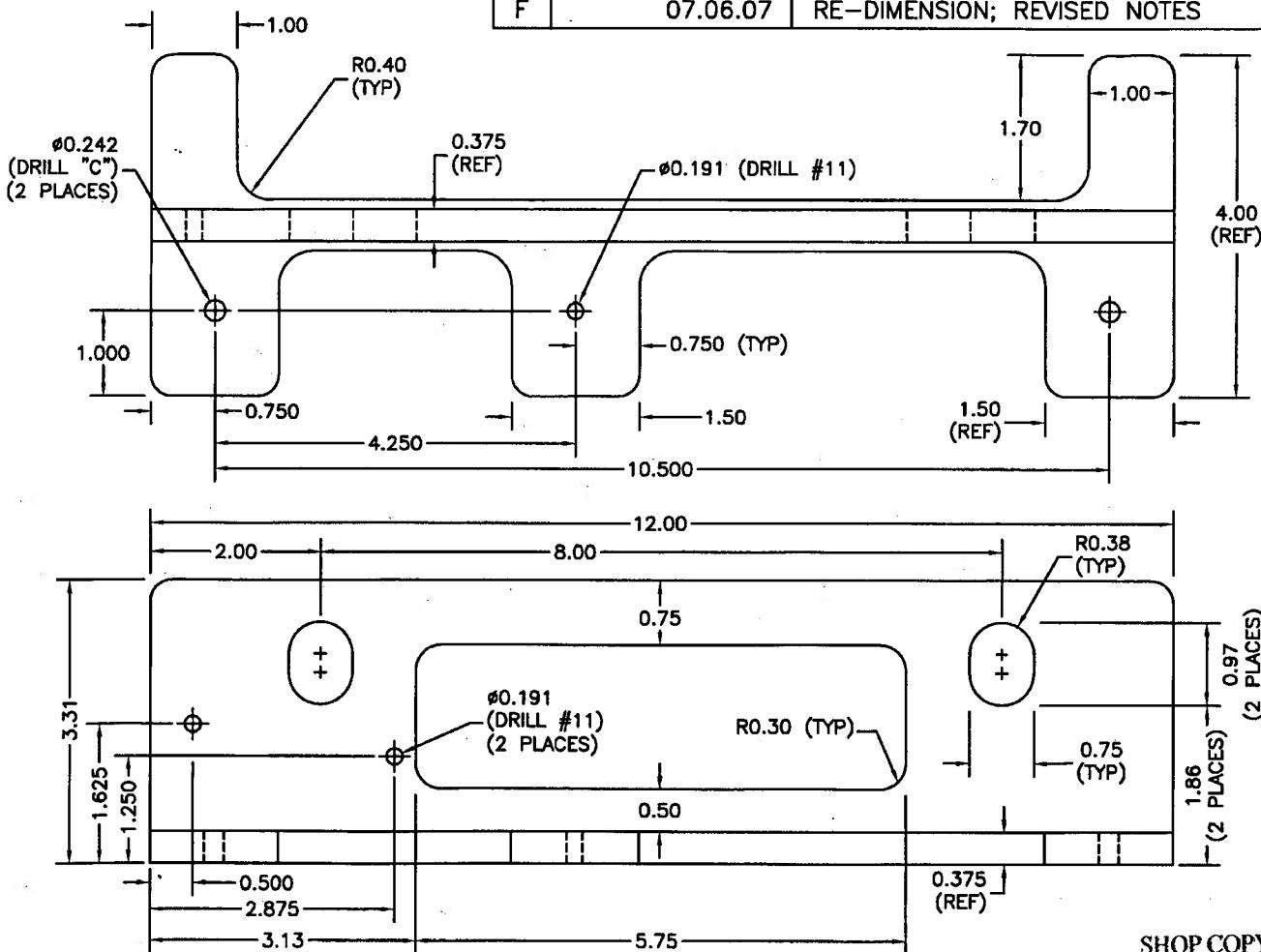
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>CH</i>	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A 95.01.14 NEW ISSUE	B 95.02.14 MODIFIED HOLES	C 95.03.06 0.191 WAS 0.197	D 95.03.06 CHANGES TO DIMENSIONS
E 97.10.01 CHANGES FOR MACHINING	F 07.06.07 RE-DIMENSION; REVISED NOTES		



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D2363 LITTER TIE DOWN BRACKET

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 SUBJECT TO AMENDMENT POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3 WITHOUT NOTICE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED NO. 42882
- 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT INK MARKER

RELEASED

07.06.07 *CH*

F

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NOTE: Date & initial all entries

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>KE 99.04.29</i>		
X 3	AD960JD10 L	WASHER
1	MS21042LB	NUT
1	MS27039-A-13	SCREW

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WITHOUT NOTICE
WORK ORDER
NO. *42882*

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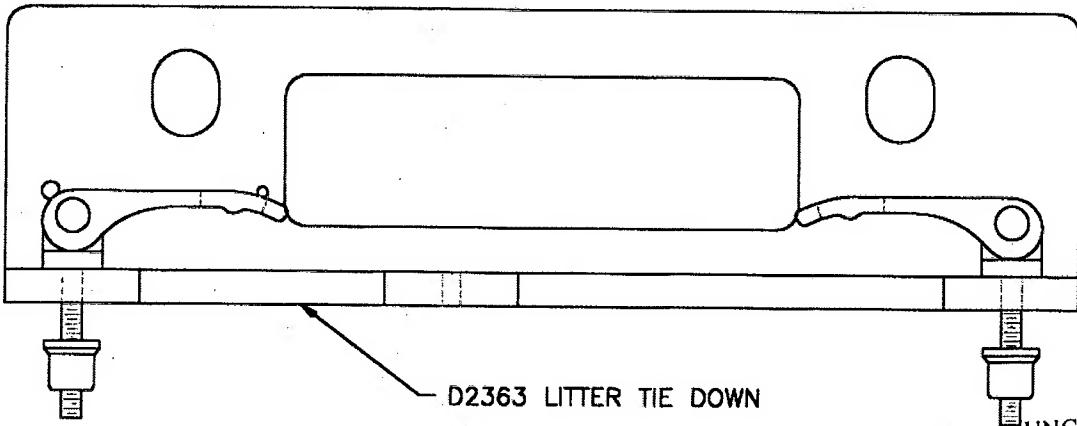
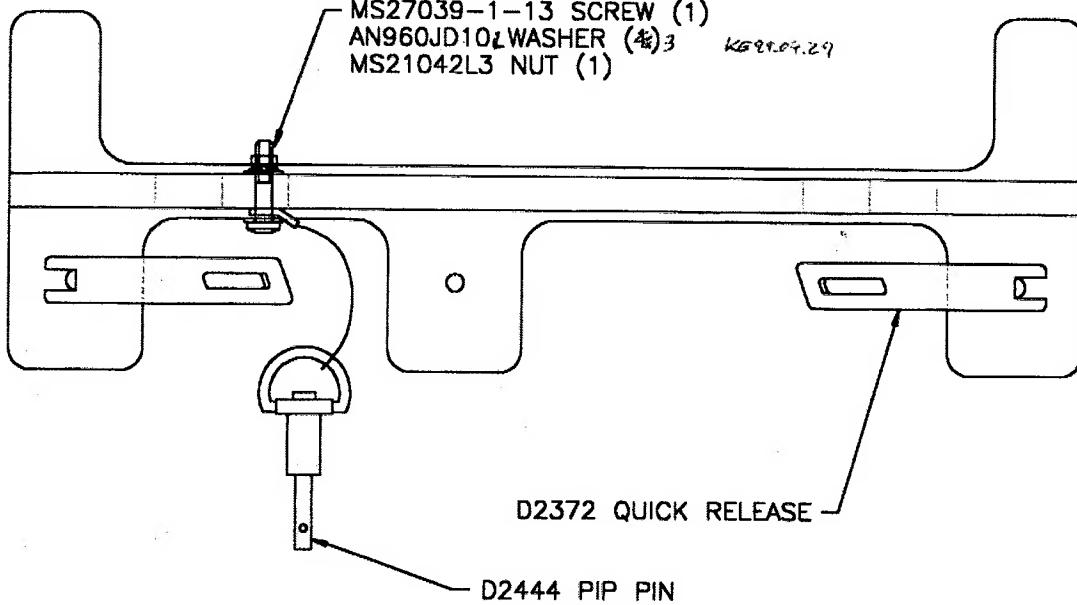
NOTE: Date & initial all entries

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>SJ</i>	DRAWING NO. D2350
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY

REV. B
SHEET 2 OF 2

SCALE

RELEASED
96 0607

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NO. *20285*

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